

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-014395**Date Inspected:** 24-May-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Mr. An Qing Xiang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance(QA) Inspector, Baskar Govindarajan, was present during the times noted above for observations relative to the work being performed.

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1.This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 251194 perform SMAW Buttering welding on, Spare strut end from 5 to 13 mm and the Strut is identified as ND1-A 468-33M-1. ZPMC CWI Identified as Mr. An Qing Xiang. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-485-SMAW-1G (1F)-Repair-1. The CWR no. found to be T-CWR-628. (Photo attached)

2.This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 044550 perform SAW welding on, Lift 5 Top side Grillage plate and the weld joint is identified as GTSA5-B/G-6A. ZPMC CWI Identified as Mr. An Qing Xiang. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2321-B-U3C-S-2.

3.This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 040690 perform SMAW welding on, Spare strut Flange to web plate and the weld joint is identified as SD1-STSA4-5-139m-1-8B. ZPMC CWI Identified as Mr. Yu Dong Ping. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2212-TC-U5B.

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4. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 057266 perform FCAW welding on, Type 1 Bearing stiffener of Shear plate ED1-A 27 and the weld joint is identified as ED1-A27 B/E-80, 81. ZPMC CWI Identified as Mr. Yu Qi Guo. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2331-TC-P4-F.

Ultrasonic Testing:

This QA inspector, Baskar Govindarajan, performed Ultrasonic Testing (UT) of approximately 10% of the area previously tested and accepted at Tower components by ZPMC Quality Control personnel. This QA Inspector generated a TL-6027 UT report for this date. The member is identified as Spare strut angle. The weld designation reviewed is as follows:

1. WD1-SA4-56-143m – Jt. no – 1 (Spare strut angle)
2. SD1-SA4-56-143m – Jt. no – 2 (Spare strut angle)
3. SD1-SA4-56-123m – Jt. no – 4 (Spare strut angle)
4. WD1-SA4-56-123m – Jt. no – 4 (Spare strut angle)
5. SD1-SA4-56-139m – Jt. no – 1 (Spare strut angle)
6. WD1-SA4-56-139m – Jt. no – 3 (Spare strut angle)

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

No relevant conversations.

Comments

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This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Skyler Guest - 15000422360, who represents the Office of Structural Materials for your project.

Inspected By:	Baskar,Govindarajan	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer
